

Work Order ID 75198

75198

Page 1

October-18-11 3:29:51 PM

Item ID: D3371-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Lock Assembly
 Start Date: 18/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3371	Rev B								

120

0.00

120

Small Fab

Small Fab

Small Fab

Memo

0.00

1- Press dowel pins as per Dwg D3371, then assemble hinge. Ensure that assembly opens & closes smoothly. Identify as D3371-051.
 2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.
 3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5
 4- Assemble lock mechanism and cam and install decal as per Dwg D3371. Apply lockite to lock body nut.

Qty	Part Number	Description	Batch
A/R		262 Lockite	<u>M119713</u>

FF 12-01-20 (4)

130

0.00

130

Small Fab

Small Fab

Small Fab

Memo

0.00

Assemble lanyard to cyclic sock as per Dwg D3384
 Identify as D3384-045

FF 12-01-20 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75198

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Page 2

October-18-11 3:29:51 PM

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 Item Name: Pedal Lock Assembly
 Start Date: 18/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00				4			
	1- Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. 2- Identify as D3371-041 & attach keys 3- Record the Key Number on page 4			FF 1201-20					
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
160 *160* Packaging	Identify as per dwg & Stock Location: <u>491</u>	0.00							
Packaging	Memo	0.00							

W 12 01 25 (4)

12/1/26 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

75198

October-18-11 3:29:51 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 18/10/2011 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 04/11/2011 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MF
12-01-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October-18-11 3:29:55 PM

Page 1

Work Order ID: 75198

75198

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			120	Each	224.0000	2	8			

238-028

3/16" Dowel Pin .5" long

**

FF 12-01-20

Location	Loc Qty	Loc Code
ST399	224	
106673	98	
108114	99	
17848	27	

AN526C832R6

Purchased

No

120

Each

330.0000

4

16

AN526C832R6

Screw

**

FF 12-01-20

Location	Loc Qty	Loc Code
ST327	330	
16612	330	

D2728-7

Manufactured

No

120

Each

0.0000

0

0

D2728-7

Dart Logo label

D3371-1

Manufactured

No

120

Each

1.0000

1

4

D3371-1

Pedal Lock Base

**

FF 12-01-20

Location	Loc Qty	Loc Code
ST485	1	

D3371-3

Manufactured

No

120

Each

0.0000

1

4

D3371-3

Pedal Lock Cover

**

FF 12-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-18-11 3:29:55 PM

Page 2

Work Order ID: 75198

75198

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3373-7 Manufactured No

120 Each 0.0000 1 4

D3373-7

Cam Lock

M22140 ** (4) 50 12/01/19

D3385-3 Manufactured No

120 Each 102.0000 1 4

D3385-3

Hinge

** FF 12-01-20

CBL-1240 Purchased No

130 f 1,000.601 1.6666 7.017263

CBL-1240

Cable

** FF 12-01-20

Location

Loc Qty

Loc Code

ST051

102

22387

102

4

Location

Loc Qty

Loc Code

GA

500

119021

500

ST284

500.601431

113565

6.311789

116438

194.289642

118207

300

7.100

CBL-460 Purchased No

130 Each 601.0000 2 8

CBL-460

Loop Sleeve

** FF 12-01-20

Location

Loc Qty

Loc Code

GA

200

119021

200

ST283

13

117947

13

ST284

388

118140

388

M 119690

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

October-18-11 3:29:55 PM

Page 3

Work Order ID: 75198

75198

Parent Item: D3371-041

D3371-041

Parent Item Name: Pedal Lock Assembly

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3384-1	Manufactured	No	77012	130	Each	0.0000	1	4	
D3384-1							**	4	FF 12-01-20
Cyclic Sock									
AN960-416	NAS1149F0463P	Purchased	No	116702	140	Each	0.0000	2	8
AN960-416							**	8	FF 12-01-20
Washer									
HX-81	Purchased	No		140	Each	18.0000	1	4	
HX-81							**	4	FF 12-01-20
1/4"-20 SHCS 3/8" long									

Location

Loc Qty

Loc Code

ST390

18

114383

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

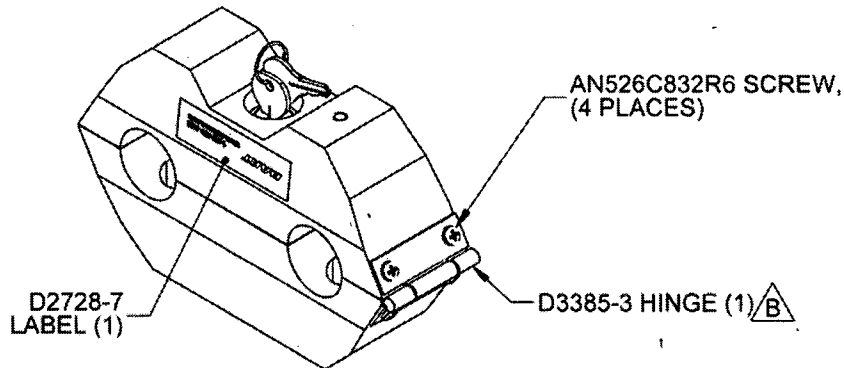
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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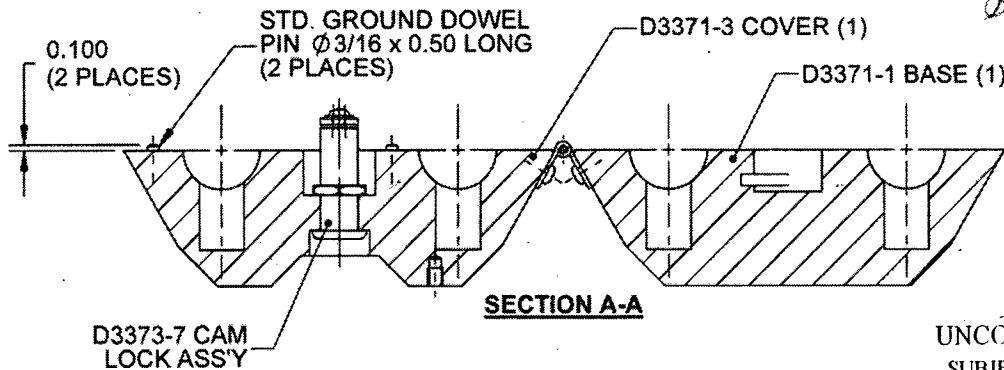


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 1 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	04.12.06	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	



PEDAL LOCK SHOWN LOCKED WITH KEY

RELEASED
[Signature]
05/04/28



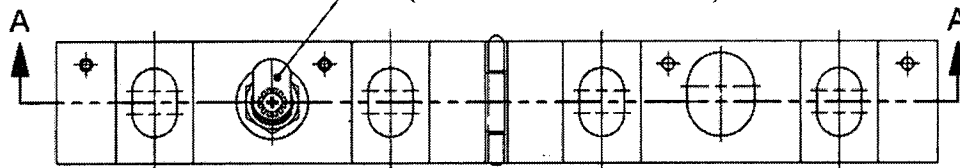
SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

D3371-5 CAM (1),
AND SQUARE WASHER SPACER (1),
EXTERNAL TOOTH LOCK WASHER (1),
#10-32 UNF PAN CROSS HEAD SCREW (1)
(AS PER D3373 DRAWING)

WORK ORDER

NO. **75198**



D3371-051 PEDAL LOCK ASSEMBLY

NOTES:

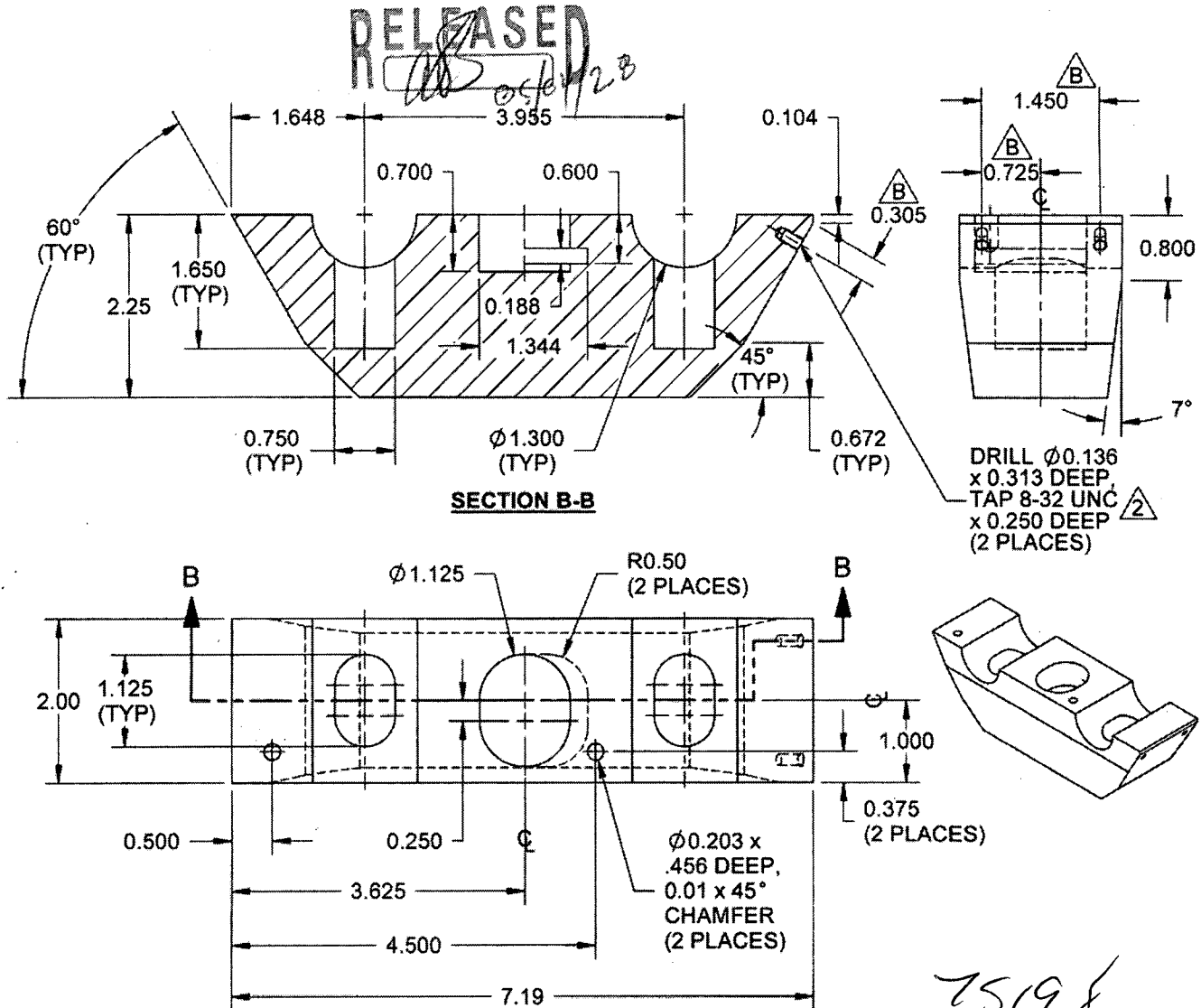
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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DATE 05.03.22	TITLE PEDAL LOCK	SCALE 1:2	



D3371-1 BASE

NOTES:

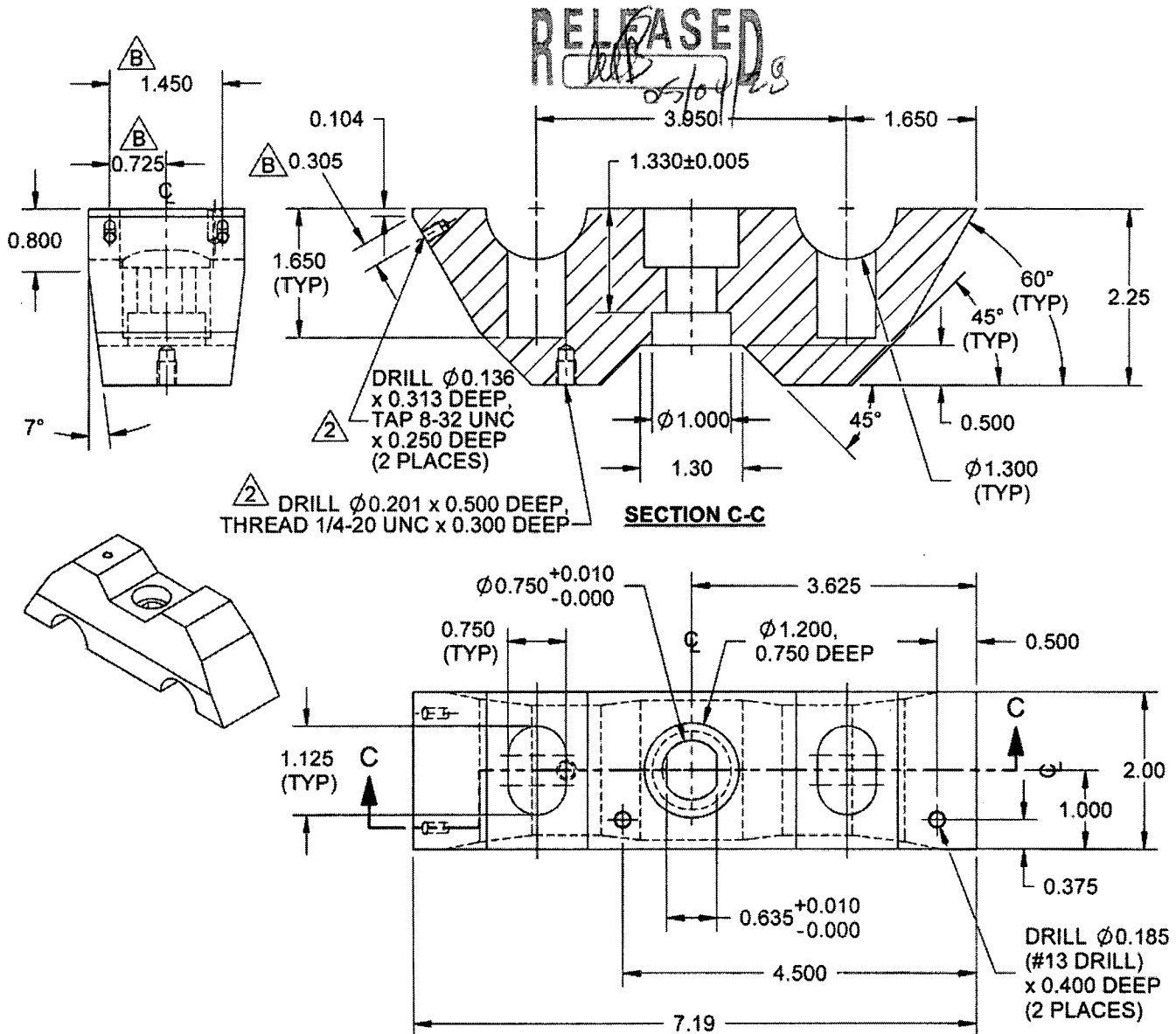
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 3 OF 4
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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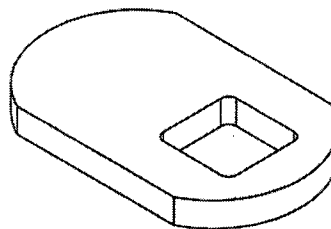
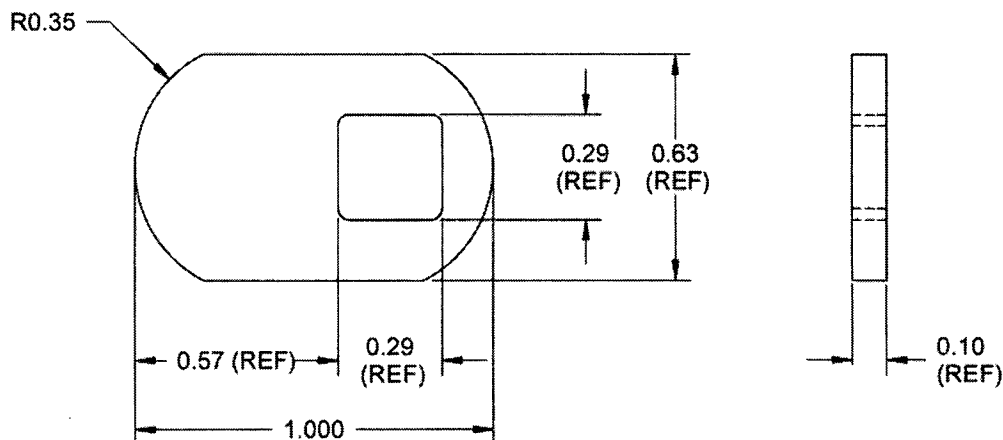
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22	TITLE PEDAL LOCK	SCALE 2:1	

RELEASED
[Signature]
05/04/28

SPECIFICATION CONTROL DRAWING



75198

D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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